

Work Order ID 132719

Thursday, May 07, 2015 2:56:47 PM

132719

Page 1

Item ID: D3459-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Float Step Mounting Plate

Stop

NS2

Start Date: 5/7/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: CL Date: MAR 08 2015

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3459	Rev A								

100 FLOW WATER JET 0.00

100

Waterjet

FLOW CNC Waterjet

6061.188 x 4"

Memo

0.00

1-Cut as per Dwg D3459

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

2 open holes to size as per dwg

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

120 QC8- Inspect parts - second check 0.00

120

QC

Quality Control

Memo

0.00

(12)

DC 15/05/21
P.T.O.

(12)

DC 15/05/21

(9)

DWG
38
9-89
MAY 28 2015

P.T.O.

DQA:

Date:

13/06/11



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

15/05/08

Work Order update only ☐

Work Order: <u>132719</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>DB459-1</u>		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☒	Engineering ☐	
NCR No <u>15-5065</u>		Scrap ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date: <u>15.02.21</u>	Step #: <u>100</u>	QTY Effective: <u>3</u>				MRB (QSI042) Approval <u>A.P.</u>	
Description Work Order Deviation		Disposition				15.02.21	
DIM 0.839 VARIES FROM ① 0.839 → 0.854 → 15-5065 RC. Tooling ② 3 piece pass in the debbur machine are scrap / too tight scrap the edge → 15-5066 RC. Operator/Training. STEP 120		MEASUREMENT DIFFICULT TO INSPECT DUE TO GRADUAL RAD. PARTS ARE ACCEPTABLE AS IS. RE-CHECK DIMS 3 pieces scrap / destroy no replace train employee proper instruction on deburring machine (record in job training log.)				Completed By <u>RC 15/05/21</u> Lead hand / Supervisor Approval Verification <u>38</u> 9-89 MAY 28 2015 QC / QA Coordinator DAS Approval <u>9</u> 9-89 15-06-05	
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☒		
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☒		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☒	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☒	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☒		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER: <u>training incomplete</u>					

Work Order ID 132719

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132719

Page 2

Item ID: D3459-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Step Mounting Plate
 Start Date: 5/7/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WA003	0.00				4x9			Dh 15/6/1
130									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL *** LOCATION: WA003								
140	QC21- Final Inspection - Work Order Release	0.00							15/6/2
140									
QC	Memo	0.00							
Quality Control									

RS-6-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Thursday, May 07, 2015 2:56:47 PM

Page 1

Work Order ID: 132719

132719

Parent Item: D3459-1

D3459-1

Parent Item Name: Float Step Mounting Plate

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: A New Issue 06-01-06 JLM
IPP Rev: B Waterjet 06-05-23 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased		No		100	f	31.5000	0.347	4.383158			

M6061T6B0 187X04 000

6061-T6 Bar .187 x 4.00

DL 15/05/21

Location

MAT001

m125590

m128265

Loc Qty

31.5

5.5

26

Loc Code

2.6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
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OTHER : ☐					

DART AEROSPACE LTD		Work Order:	132719
Description: Float Step Mounting Plate		Part Number:	D3459-1
Inspection Dwg: D3459 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	Ø.256	/		V:DC-02	
2.715	+/-0.010	2.715	/			
0.250	+/-0.010	.253	/			
R0.125	+/-0.010	.125	/			
R0.063	+/-0.010	.063	/			
0.839	+/-0.010	.854	/			
0.188	+/-0.010	.184	/			

Measured by:	DC	Audited by:	EP	Prototype Approval:	N/A
Date:	15/05/21	Date:	15-05-28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.26	New Issue	KJ/EC/DD	EP